

Work Order ID 78528

January-11-12 7:48:31 AM

\*78528\*

Page 1

ASAP

Item ID: D4073-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Door Hinge

Start Date: 11/01/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 18/01/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/11

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4073	B

100

Cut blanks as per folio

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

cut blank 4.563" long

cut 12/01/26

20

105

0.00

\*105\*

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg an Folio FA939

Dwg Rev: B

Folio Rev: AA

2/22

20

12/01/27

Deburr

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78528

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January-11-12 7:48:31 AM

Item ID: D4073-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Door Hinge  
 Start Date: 11/01/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 18/01/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 <b>*110*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00				20	0		12/01/27
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				20	0		12/01/28
150 <b>*150*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				20	0		12-1-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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January-11-12 7:48:31 AM

Item ID: D4073-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Door Hinge  
 Start Date: 11/01/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 18/01/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*160*</b>									
Powdercoat	Memo								
Powder Coating									
m 119480									
			Start Time: 11-00			20 X M-L 12/01/31			
			Temp: 3200 F						
			Finish Time: 11-30						
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
						20 BL 12-1-31.			
180	Identify as per dwg & Stock Location: 120	0.00							
<b>*180*</b>									
Packaging	Memo	0.00							
Packaging									
						12/1/31 P 20.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 78528****\*78528\***

Page 4

January-11-12 7:48:31 AM

Item ID: D4073-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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Item Name: Door Hinge  
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Required Date: 18/01/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

12/2/11 JF  
ME  
12-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

January-11-12 7:48:35 AM

Page 1

Work Order ID: 78528

**\*78528\***

Parent Item: D4073-1

**\*D4073-1\***

Parent Item Name: Door Hinge

Start Date: 11/01/2012

Required Date: 18/01/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD IPP  
REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS  
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased		No		100	f	39.6026	0.38	8			

**\*M6061T6B2 000X01 250\***

**\*\***

6061-T6 Bar 2.00 x 1.25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT009	39.60263158	
114899	4.15263158	
116623	2.15	
→ 119136	33.3	

8 *Sh* 12/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	78528
<b>Description:</b> Door Hinge		<b>Part Number:</b>	D4073-1
<b>Inspection Dwg:</b> D4073 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.13	+/-0.030	.130	/		R-G	
Ø0.203	+0.005/-0.001	.206	/		vern .13	
2.00	+/-0.030	2.001	/		"	
0.81	+/-0.030	.800	/		"	
0.350	+/-0.010	.350	/		"	
1.100	+/-0.010	1.100	/		"	
Ø0.500 x 0.125	+/-0.010	500x.124	/		"	
0.340	+/-0.010	.340	/		"	
1.320	+/-0.010	1.320	/		"	
4.44	+/-0.030	4.437	/		"	
4.13	+/-0.030	4.124	/		H-G	
R0.31	+/-0.030	.31	/			
0.313	+/-0.010	.314	/		vern .13	
0.63	+/-0.030	.624	/		"	
1.00	+/-0.030	1.002	/		"	
0.38	+/-0.030	.376	/		"	
0.190	+/-0.010	.192	/		"	
1.80	+/-0.030	1.800	/		"	
0.25	+/-0.030	.252	/		"	
R0.13	+/-0.030	.125	/		R-G	

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	B.A.	<b>Preliminary Approval:</b>	
<b>Date:</b>	12-01-28	<b>Date:</b>	12/01/28	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

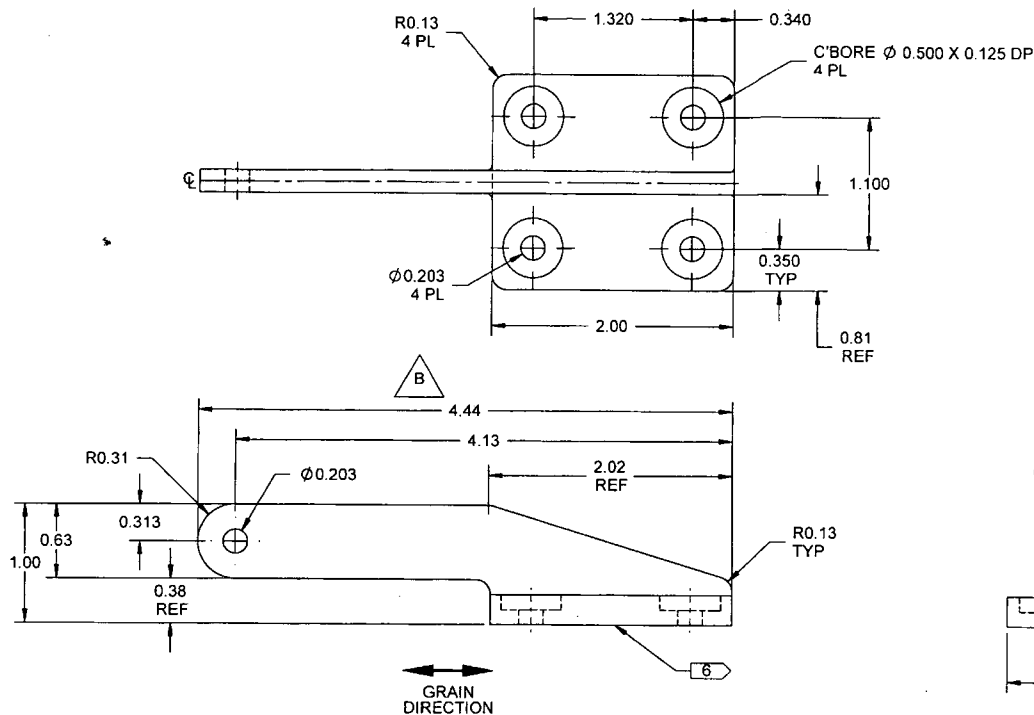
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

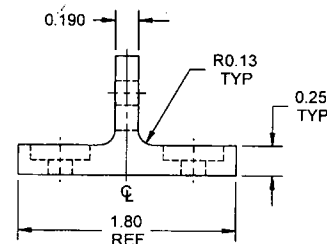


**D4073-1 DOOR HINGE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

SHOP COPY  
RETURNED  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHOUT REUSE  
WORK ORDER  
NO 78528 H.C.J  
12/01/11



**RELEASED**  
2011-06-30  
JWP

B	4.44 WAS 3.75; 4.13 WAS 3.44 (ZN C6-1)	RF	11.05.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.02		
<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D4073</b> TITLE <b>DOOR HINGE</b> REV. B SHEET 1 OF 2 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

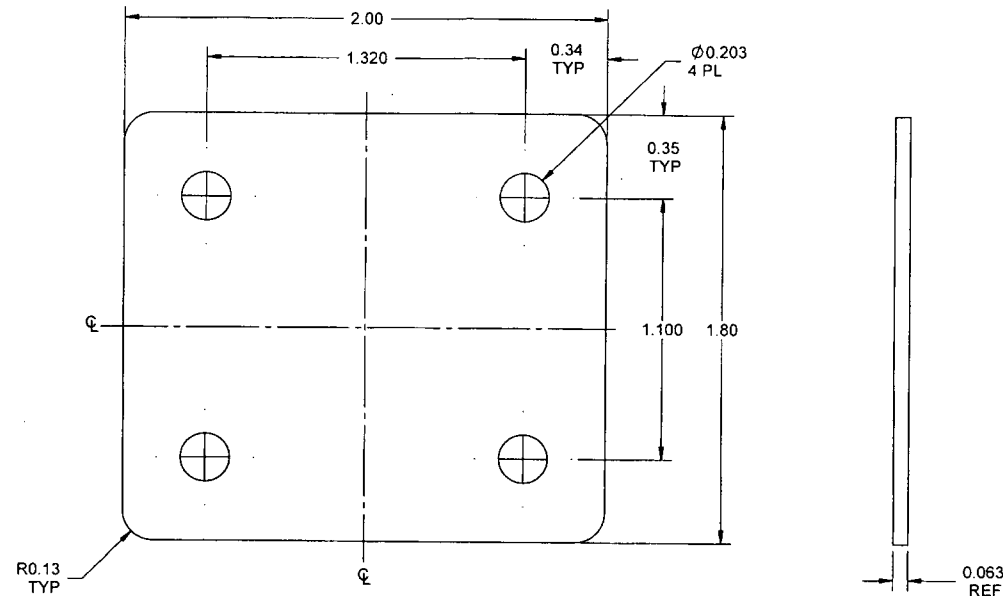
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78528



**D4073-3 DOOR HINGE BACKING PLATE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

**RELEASED**  
2011-06-30  
NP

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4073	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DOOR HINGE	NTS
DATE	11.05.02	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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